



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBH9928-2
Job Sheet 171774



Part No: RBH9928-2

Job Qty: 10 ea

Part Name: Tab Bender with Plastic Block



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/8/18

Job Tracking No:

Due Date: 3/2/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBH9928-2 Rev K IPP Rev A 17.11.13 New Issue DP Verify DD/IPP Rev B 17.11.20 DWG Rev K DP
Verify DD IPP Rev.C 18.01.18 Updated process, all done under assy. JFS Verified by: DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	3/1/18	3/1/18	0.00	0.00	Start Up Machining-4		J.C.-L.
100	Bandsaw	10 pcs	3/1/18	3/1/18	0.00	0.25	Bandsaw1		J.C.-L.
110	Mori Seiki	10 pcs	3/1/18	3/1/18	0.00	5.00	MORI NV5000-1		J.C.-L.
120	QC	10 pcs	3/1/18	3/1/18	0.00	0.00	QC2 Machining-5		J.C.-L. 18-05-16
130	QC	10 pcs	3/1/18	3/1/18	0.00	0.00	QC8-7		B.E. 18-05-29
140	Brake NC	10 pcs	3/1/18	3/1/18	0.00	5.00	Brake NC 1		DAE
155	QC	10 pcs	3/1/18	3/1/18	0.00	0.00	QC5		38
165	Outsource	10 pcs	3/1/18	3/1/18	0.00	0.00	Outsource4		CT 18-5-31
175	Packaging	10 pcs	3/1/18	3/1/18	0.00	0.00	Packaging2		AT 18-06-06
180	QC	10 pcs	3/1/18	3/1/18	0.00	0.00	QC6		PO. B. 18-07
190	Small Fab	10 pcs	3/2/18	3/2/18	0.00	5.00	Small Fab		all
200	QC	10 pcs	3/2/18	3/2/18	0.00	0.00	QC5		SB
210	Packaging	10 pcs	3/2/18	3/2/18	0.00	0.00	Packaging3		GA 18-06-07
220	QC21-SA	10 Ea	3/2/18	3/2/18	0.00	0.00	QC21		21 JUN 07 2018

Part Op 100 - Cut blanks to 8.00"

Descriptions: 110 - 1-Machine RBH9928-2-1 & RBH9928-2-3 as per folio FB676 FOLIO REV: _____ DWG REV: _____

2-Deburr NOTE; ***Machine both parts at same time***

130 - Engrave T/N number ONLY (RBH9928-2) using Marktronic engraver as per DWG.

140 - Form RBH9928-2-1 as per DWG. -Remove bending marks -Broach RBH9928-2-3 as per DWG. -Tumble to remove buffer marks

165 - Issue P/O to ATG : PO 040072 ***ENSURE TO SHIP BOTH PARTS*** -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Certificate of Conformity is required

190 - Assemble as per DWG. Sheet 1

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S0.250X6.250	6061-T651 Sheet 0.250" Thick Plate x 6.250" Wide	6.6600 ft (.666 ea)	90-Start up Operation	5042 201 5045 654
92356A247	Carriage Bolt 54	20 Ea (2 ea)	190-Small Fab	5011315
96659A104	Washer 39	20 Ea (2 ea)	190-Small Fab	5011316
KKT-11A	Knurled Knob 54 563	20 Ea (2 ea)	190-Small Fab	13X 5044356 7X 5016738

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

90-Start up Operation
190-Small Fab

M6061T6S0.250X6.250
92356A247
96659A104
KKT-11A

7
20
20
20

11
50
100
30
71
47
0
0
0
0

Part Specifications

Specifications could not be found.

(4/26)

Plex 2/8/18 11:15 AM Dart.lajeunesse.marie



Container No: S071946



Part: RBH9928-2

Job No: 171774

Serial No/Batch: S071946

Revision: K

Inspector:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 05/16/18

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

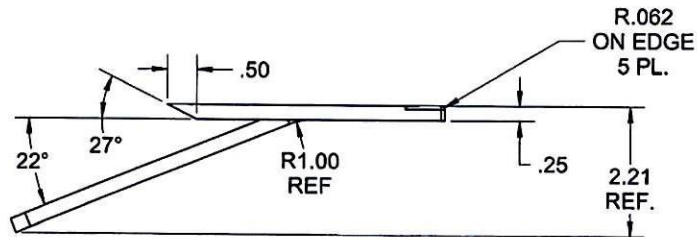
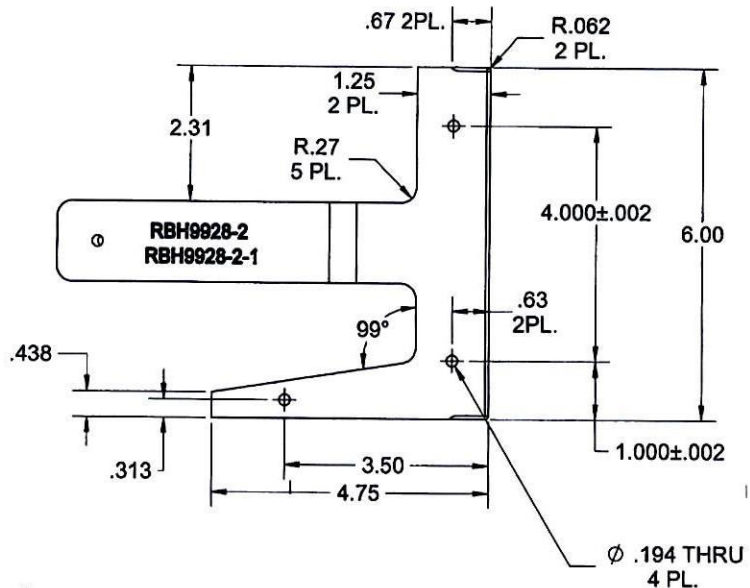
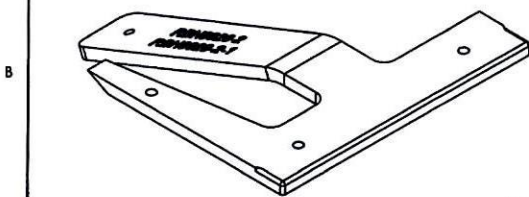
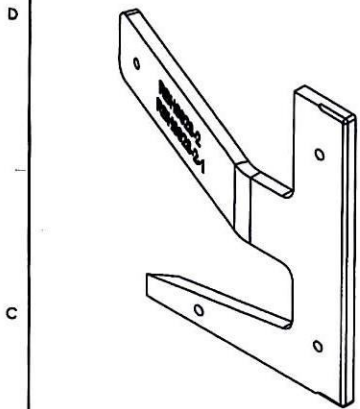


QA Closed: _____ Date: _____

Work Order update only ☐

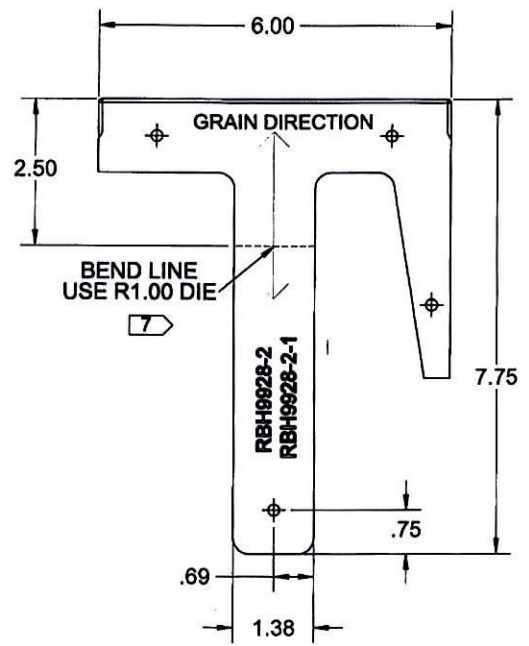
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

8 7 6 5 4 3 2 1



RBH9928-2-1 TAB BENDER

- NOTES:
- 1) MATERIAL: 6061-T6
 - 2) FINISH: RED ANODIZE
 - 3) HEAT TREAT: N/A
 - 4) SPEC: MIL-A-8825, TYPE II, CLASS 2; WATER SEALANT
 - 5) BREAK ALL SHARP EDGES .015 x 45° OR .015R
 - 6) IDENTIFICATION: ENGRAVE T/N & S/N, ARIAL REGULAR, 1/4" HEIGHT, 0.010" DEPTH
 - 7) NO DIE MARKS



FLAT PATTERN

DART AEROSPACE		Newmarket, Ontario, Canada	
TAB BENDER			
DWG NO.		REV K	
RBH9928-2-1			
DESIGN BY:	VM 9/22/2017	XXX ± .005	FRACTIONS & 1/8
DRAWN BY:	WM 11/15/2017	XX ± .01	ANGLES & 1/2
CHECKED:	WM 11/15/2017	1	SURFACES ± 1/2
MFG. APPR:	DP 11/16/2017	1. DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED	
APPROVED:	WM 11/16/2017	2. INTERPRET DIMS AND TOL PER ASME Y14.5M-2009	
DATE:	1/15/2017	3. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE:	NTS	WEIGHT:	0.5 LBS
		SHEET 2 OF 3	
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8 7 6 5 4 3 2 1



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO040072

Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO040072
PO Date: 5/31/18
Due Date: 6/6/18
**Purchase Order
Revision:**
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Via: Ground
Pynt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	171774	RBH9928-2	Trim Tab Bender -Issue P/O to ATG : PO ***ENSURE TO SHIP BOTH PARTS*** -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Certificate of Conformity is required	Firmed	6/6/18	10 pcs	0 pcs	10 pcs	\$25.00/pcs	\$250.00
Grand Total:										\$250.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 6/6/18 11:49 AM dart.tsimiklis.chrisoula



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 915316

Date: 06-Jun-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chrisoula Tsimiklis
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		OUR TRUCK	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
10 ea	Part: RBH9928-2 Trim Tab Bender	Rev: K	
DAS 9 9-89	Anodize per MIL-A-8625F, Type II, Class 2, Red, .0004-.0010" (.4 - 1 mils). Water Sealant Job: 23196	PO: PO040072	Line: 1
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>6/6/18</u> Certified Signature: <u>Ive Richad</u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			
Made in Canada			